



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3101-86-101-1

Job Sheet 189581



Part No: RBW109-3101-86-101-1

Job Qty: 4 pcs *12* *DAS*

Part Name: Ring, 1-3/4 x 1-3/4 x 3-7/8



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 3/15/19 *April 4*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3101-86-101 Rev.A IPP Rev. A 19.01.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	SL-2500Y-1	4 pcs	3/15/19	3/15/19	0.00	1.33	SL-2500Y - 1	<i>PJ 14-03-21</i>
110	QC 2	4 pcs	3/15/19	3/15/19	0.00	0.00	QC 2 - 1	<i>PJ 14-03-21</i>
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	<i>J.C.</i>
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165207



Part: RBW109--3101--86--101--1

Job No: 189581

Serial No/Batch: S165207

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 03/22/19

Plex 1/28/19 2:30 PM Dart.lajeunesse.marie

120 QC 8	4 pcs	3/15/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Δ-A 19-03-24
				QC 8 - 9	
				QC 8 - 68	
125 Outsource - 4 - Anodize	4 pcs	3/15/19		GRO002-VC	03/25/2019 PC
126 Packaging 2-1 - Receive - B4B	4 pcs	3/15/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
127 QC 6	4 pcs	3/15/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	MAR 29 2019 68
					9-89
130 Packaging 3-1 - Stock - B4B	4 pcs	3/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
140 QC 21 - SA	4 pcs	3/15/19	0.00 0.00	QC 21 - SA - 21	

Part Op 100 - 1-Machine as per folio FC 711 FOLIO REV: A DWG REV: A 2-Deburr ***Makes
 Descriptions: 3 pcs at a time***
 125 - Issue P/O; _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -
 Material type; 6061T6 -Certificate of Conformity is required
 126 - C of C required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R5.500	6061T6 Round-Bar 5.500" Dia.	.6240 ft (.156 ea)	100-SL-2500Y - 1	5152415
	<u>1.750 x 1.750</u>	<u>0.766 long</u>		

Job Allocations

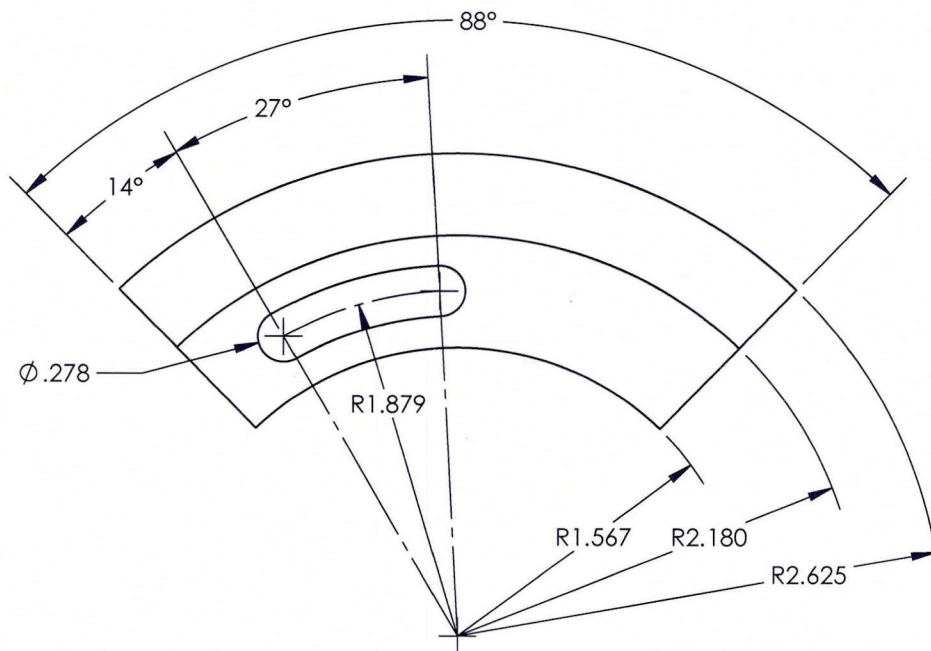
Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	M6061T6R5.500	1	3	0

Part Specifications

Specifications could not be found.

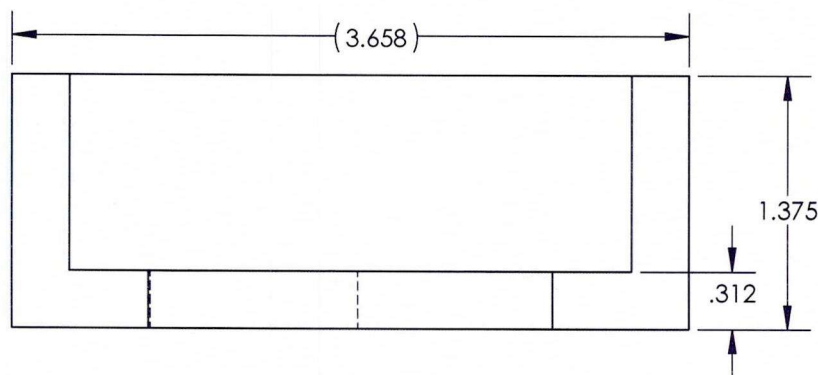
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SHOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189581 MJS
1901-28

(-1)
RING



RED BARN MACHINE	
TITLE TOOL ASSY. FLOATING RING CENTERING	
DWG NO. RBW109-3101-86-101-1	REV A
MAT'L 6061	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH CLEAR ANODIZE
.X ± .1	ANGLES ± .5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL A109E, A119
SCALE 1:1	DATE 12/18/2012
SHEET 2 OF 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

PO042980



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042980

PO Date: 3/25/19

Due Date: 4/1/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189581	RBW109-3101-86-101-1	Ring, 1-3/4 x 1-3/4 x 3-7/8 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/1/19	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
							12 x	MAR 29 2019			DAS 68 9-89
2	189284	RBE703A95-0520-01-1	Quill Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	4/1/19	22 pcs	0 pcs	22 pcs	\$5.46/pcs	\$120.12
							22 x	MAR 29 2019			
Grand Total:											\$240.12



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PURCHASE ORDER PO042980



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/26/19 1:31 PM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance



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2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

017969- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Mar-2019		Shankar Anand		042980 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW109-3101-86-101-1 Rev. ✓	RBW109-3101-86-101-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	12	12 ✓	0	0	DAS 68 9-89
2	RBE703A95-0520-01-1 Rev. ✓	RBE703A95-0520-01-1 01 -ANO-RED [ANODIZE RED] ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	22	22 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.